

Date: Wednesday, 3/8/2006 10:28:11 AM  
 User: Kim Johnston

## Process Sheet

15

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY LH  
 Job Number : 26091  
 Estimate Number : 10262  
 P.O. Number : NIA Part Number : D350636011  
 This Issue : 3/8/2006 S.O. No. : NIA Drawing Number : D2750 REV C1  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : NIA Type : LANDING GEAR Drawing Revision : C1  
 Previous Run : 26090 Material : NIA  
 Written By : *See Comment Below* Due Date : 4/15/2006 Qty: 1 Um: Each  
 Checked & Approved By : *06.03.08*  
 Comment : Est Rev: 02/09.25 Rearranged procedure steps KJ

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-011CHG 001

DA 06.03.21

2.0

D26003BENT

Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

B25384 Pm 06-03-09

3.0

D2744

Fwd Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2744

Cap

24672 BE 06-04-05

4.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-3-Bent aft end to length as per Dwg D2750 Mark cut line using Jig DT 8150. Deburr end Pm 06-03-09

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1) and mark fwd end for cutting using Drill Jig DT 8150. Second side of Detail B to be Drilled using DT 8330 Pm 06-03-09

3-Open up holes for Detail B, D and 2 aft 0.500" AE holes to finished size as per Dwg D2750 and DEO 9133 Do not open any 0.625" AE holes to finished size Pm 06-04-04

4-Drill pilot holes as per Dwg D2750 (Sheet 3, D2750-1), mark Fwd end for cutting using Drill Jig Pm 06-04-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:28:11 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 26091

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

DT8150, then drill both sides.

5-Open holes as per detail "P" To 500", then Drill pilot holes to detail "B" using DT8330  
\*\*\*Make sure that wearplate holes are on bottom of tube\*\*\*\*\*

6-Open holes to .500" as per detail "B&C".

7-Open holes to .375" as per detail "D"

8-Cut fwd end of tube as per Dwg D2750

9-Drill pilot holes for wearplates using DT 8108 Open holes to 0.297" and Open holes per Dwg D2750 detail A

10-Open holes to .590" as per detail "D".

11-Deburr

12-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004  
A/R Aluminum Rod *m 19101 BE 06-04-05 ①*

13-Grind welds flush as per Dwg D2750

*BE 06-04-06 ①*

*Pm 06-04-04*

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*Pm 06-04-06 ①*

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

*ID 06-04-07 / 06-4-7*

7.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D2739 Web *B26385*

*Pm 06-04-07 ①*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:28:11 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 26091

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 D2743

Crossbolt spacer

*224240 BE 06-04-11 (1)*

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open 0.625" AE holes and countersink for welding crossbolt spacers as per Dwg D2750. Do not use cutting oil *pm 06-04-07 (1)*

2-Deburr and blow-out all chips from inside of tube *pm 06-04-07 (1)*

3-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

Sikaflex expire date: *06-01-01*

*m100480 pm 06-04-07 (1)*

4-Weld crossbolt spacers D2743 as per Dwg D2750 and QSI 004

A/R Aluminum Rod

*m19101 BE 06-04-11 (1)*

5-Grind welds flush as per Dwg D2750

*ST 06-04-11 (1)*

6-Spot face ground handling holes AE0.750" (8 places)

*ST 06-04-11 (1)*

7-Deburr holes

*ST 06-04-11 (1)*

10.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and work to Step 20

*06-04-17 (1)*  
*PD 06-04-17*

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

*A-m 06-07-24 (1)*

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

*FL*

*06 07 24 (1)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 3/8/2006 10:28:12 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 26091

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D27421

Blade Fitting, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2742-1	Blade Fitting, LH	B25111

14.0

AN835A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN8-35A	Bolt	(2x) M18576 (2x) M101291

15.0

AN960JD816

1/2" washer, Alum



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN960JD816	Washer	M6956

16.0

MS21083N8

Nut



1



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS21083N8	Nut	M19099

17.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
5	D2648-3	Wearpad	B 25904

18.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2656-13	Wearplate	B27074

am 06-07-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Wednesday, 3/8/2006 10:28:12 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 26091

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

19.0	D265635	Wearplate
------	---------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2656-35	Wearplate	927258

20.0	D2746	Wearshoe
------	-------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2746	Wearplate	625841

21.0	ALS41032225	Insert
------	-------------	--------



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
46	ALS4-1032-225 ✓ (or AKS4-1032-225) (or ALS7-1032-225) (or AKS7-1032-225)	Insert	M100989

22.0	AN960JD10L	Washer
------	------------	--------



Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
42	AN960JD10L	Washer	M101291

23.0	AN35A	Bolt
------	-------	------



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
42	AN3-5A	Bolt	M15205 a.m 06-01-29 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:28:12 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 26091

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN36A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-6A	Bolt	m100274

25.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	D2745	Bushing	m27147

26.0

AN644A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN6-44A	Bolt	m19471

27.0

MS21042L6

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	MS21042L6	Nut (or -6)	m19099

28.0

AN332A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-32A	Bolt	m14600

(2x) m100188

Q m 06-07-24 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:28:12 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 26091

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

A3235020935

Washer - Countersunk



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	A3235-020-935	Plug	m18369

30.0

MS21042L3

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	MS21042L3	Nut	m100393

31.0

AN36A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-6A	Bolt	m100374

32.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN960JD10	Washer	m100151

a.m. 06-07-24

33.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Assemble as per Dwg D2750 Page 4 Detail P. Install D2742-2 and seal with Sikaflex adhesive prior to installing aft most wearpad. Ensure holes are properly aligned.

A/R Sikaflex-291 m101193

Sikaflex expire date: 06-11-06

2-Install inserts & wearplates as per Dwg. D2750 Detail K & Q and IIN-D350-636 Page 4. Use a drop of Sikaflex in insert holes before installing wearpad/wearplate. AN3-6A bolts are installed AFT.

A/R Sikaflex-291 m101193

Sikaflex expire date: 06-11-06

a.m. 06-07-24

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 3/8/2006 10:28:12 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 26091

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Install D2745 Bushing as per Dwg. D2750 Detail M

4-Install A3235-020-935 Plug as per Dwg. D2750 Detail L

5-Install AN3-6A Bolt as per Dwg. D2750 Detail Q

34.0

QC5

INSPECT WORK TO CURRENT STEP



*MA*

*06 07 25*



*①*

Comment: INSPECT WORK TO CURRENT STEP

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

36.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

Batch

1 D2741

Blade

*B25938*

37.0

AN960JD816

1/2" washer, Alum



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

Batch

2 AN960JD816

Washer

*M6956*

38.0

MS21083N8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

Batch

2 MS21083N8

Nut

*M100993*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/08/01  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Wednesday, 3/8/2006 10:28:12 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 26091

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

AN816A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

Batch

2 AN8-16A

Bolt

MES760 ✓

PO 6/17/27 ①

40.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AB 06/01/31 ①

41.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-011

Rev-D

AB 06/01/31 ①

42.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/01 ①

Job Completion



06.08.01

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



RELEASED  
98.12.16 DS

DESIGN <i>DAH</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>DAH</i>	APPROVED <i>KE</i>	DRAWING NO. D2750	REV. C SHEET 1 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740	
CI	<i>CP</i> 05.01.20	CHANGE QTY WEARSHOE HOLES, AS MANUFACTURED	

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
3	3	3	3	D2648-3	WEARPAD
2	2	2	2	D2648-5	WEARPAD
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
1		1		D2742-1	BLADE FITTING, LH
	1		1	D2742-2	BLADE FITTING, RH
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
8	8			A3235-020-935	PLUG
<del>40</del>	<del>40</del>	<del>40</del>	<del>40</del>	AN3-5A	BOLT
8	8	8	8	AN3-6A	BOLT
4	4			AN3-32A	BOLT
4	4	4	4	AN6-44A	BOLT
2	2	2	2	AN8-16A	BOLT
1	1	1	1	AN8-35A	BOLT
3	3	3	3	MS21083N8	NUT
4	4			MS21042L3 OR MS21042-3	NUT
4	4	4	4	MS21042L6 OR MS21042-6	NUT
4	4	4	4	AN960JD10	WASHER
<del>44</del>	<del>44</del>	<del>44</del>	<del>44</del>	AN960JD10L	WASHER
4	4	4	4	AN960JD816	WASHER
<del>44</del> 42	<del>44</del> 42	<del>44</del> 42	<del>44</del> 42	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

EFFECTIVE	DEOS
D2750-041 DS	D2750-042 DS
48.01.19 DS	49.10.21 DS

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26091



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2750	REV. C SHEET 2 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

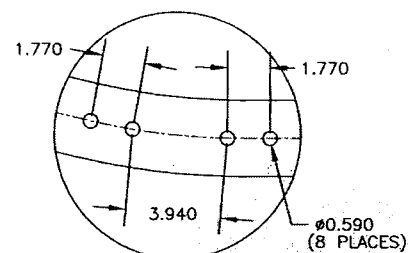
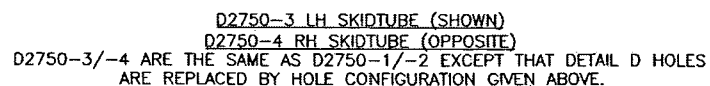
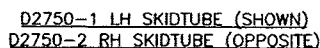
GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
3. DAMAGE TOLERANCE ON BENDING:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.15 \pm 0.030$  IN THE BENT PORTION OF THE TUBE.
4. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E AND F-F.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
7. FINISH:  
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2734 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
8. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4.
9. D2742-1 (OR D2742-2) BLADE FITTING AND AN3-5A/AN3-6A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.

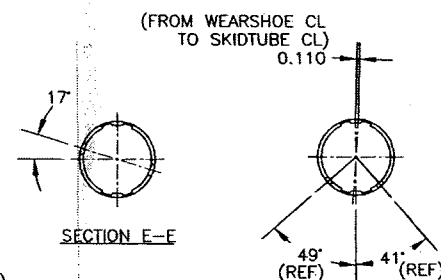
EFFECTIVE	DEOs
DEO 9133 98.01.19 DS	DEO 9157 99.10.21 DS

**RELEASED**  
98.12.16 DS

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26091



DETAIL D  
(ALL DIMENSIONS ARE  
STRAIGHT LINE DIMENSIONS)



SECTION F--F

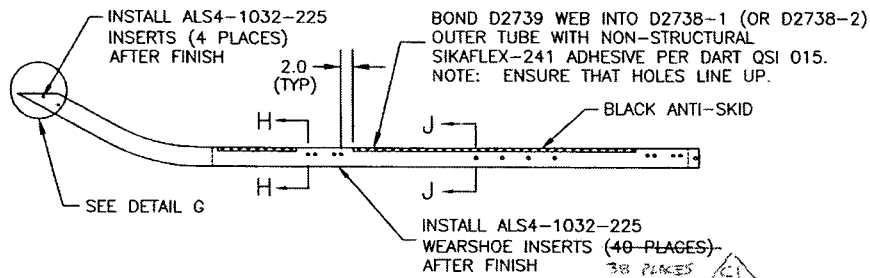
RELEASE  
98.12.16 DS

EFFECTIVE	DEOs
000 4133 98.01.19 DS	000 1157 99.10.21 DS

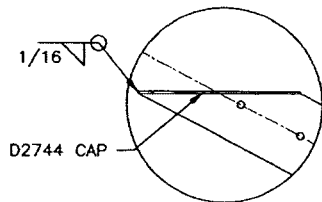
DESIGN #1	DRAWN BY P	 DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED P	APPROVED HE	
DATE 98.11.18	TITLE 350 SKIDTUBE ASSEMBLY	REV. C SHEET 3 OF 4 SCALE 1:20

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26091

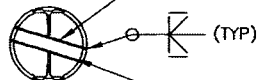
D2750-1/-2/-3/-4 WELDING DETAIL  
(FLOAT ATTACHMENT HOLES REMOVED)  
D2750-1/-3 SHOWN (D2750-2/-4 OPPOSITE)



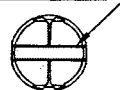
DETAIL G



SECTION H-H D2743 SPACER (REF)



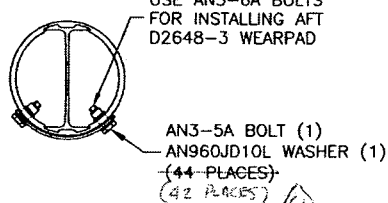
SECTION J-J



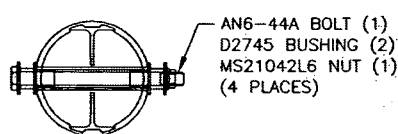
WELDING INSTRUCTIONS

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO Ø0.484
6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

DETAIL K



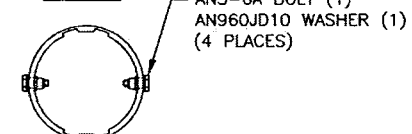
DETAIL M



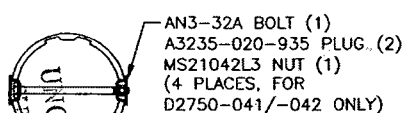
DETAIL P



DETAIL Q



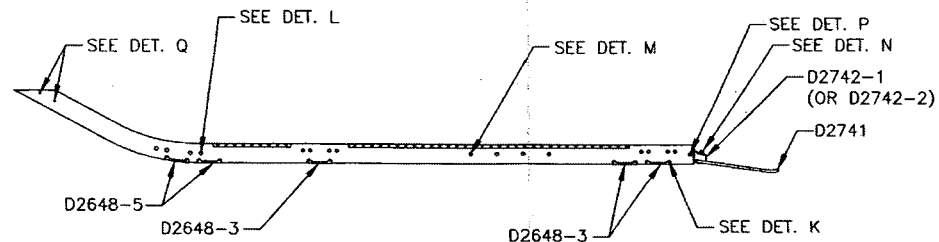
DETAIL L



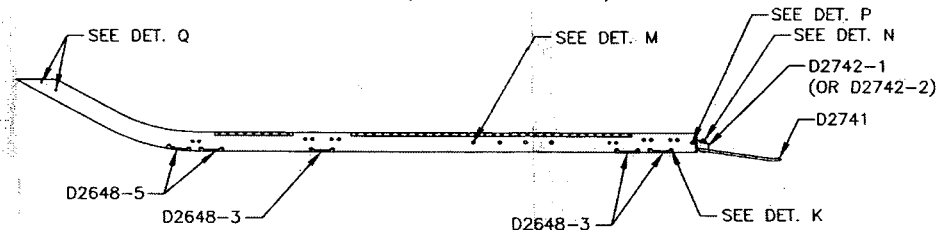
DETAIL N



D2750-041/-042 ASSEMBLY  
D2750-041 SHOWN (D2750-042 OPPOSITE)



D2750-043/-044 ASSEMBLY  
D2750-043 SHOWN (D2750-044 OPPOSITE)



RELEASED  
98.12.16 DS

EFFECTIVE	DEOs
DES 9133 98.01.19 DS	DES 9157 99.02.21 DS

DESIGN #	DRAWN BY CP	<b>DART</b> DART AEROSPACE USA, INC. BELLINGHAM, WA	REV. C
CHECKED #	APPROVED KE	DRAWING NO. D2750	SHEET 4 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:20

NO. 26071  
WORK ORDER  
WITH OUT NOTICE  
UNCONTROLLED COPY  
RETURN TO  
ENGINEERING  
SHOP COPY

